



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66183**

Monday, February 07, 2011 11:50:40 AM



Page 2

Item ID: D2056

Accept



Setup Start



Revision ID:

Stop



Item Name: Bell Crank

Start Date: 2/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B-A 11/03/22

10

φ

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BL 11-3-22

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30  
320°  
11:00

10 BL 11-3-25.

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**Work Order ID 66183**

Monday, February 07, 2011 11:50:40 AM

Page 3

Item ID: D2056

Accept

Setup Start

Revision ID:

Stop

Item Name: Bell Crank

Start Date: 2/8/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 M-1 11/03/26

170

Identify as per dwg &amp; Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

SB 11/03/28

(10)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/03/29

U 11/03/20

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# Picklist Print

Monday, February 07, 2011 11:50:36 AM

Page 1

Work Order ID: 66183

Parent Item: D2056

Parent Item Name: Bell Crank



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP E02.04.04 Added Rev.B2 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	24.9275	0.2375	2.3333			



6061-T6 Bar 1.25 x 1.25



Location

Loc Qty

Loc Code

MAT

17.633

116135

17.633

MAT03

7.294450526

106259

7.06921053

110001

0.22524

2.33

only 11/03/18

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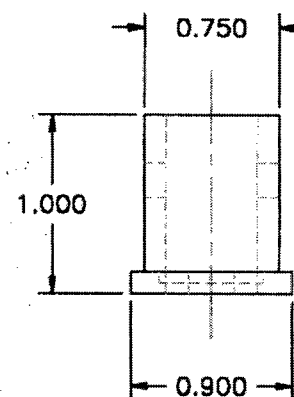
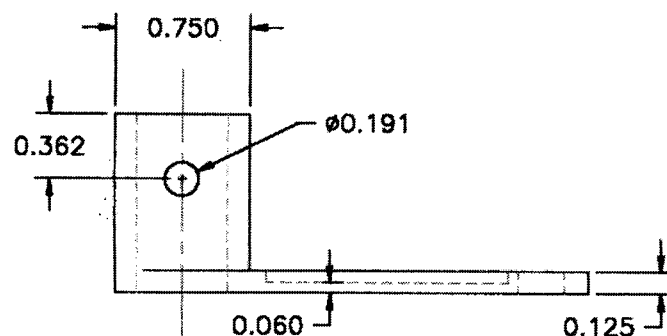
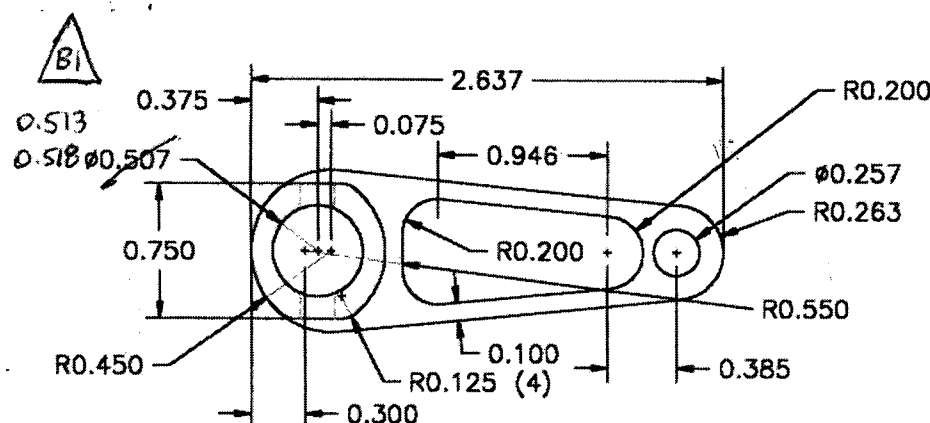


**DART**



RELEASED  
990425 AE

DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED B1	APPROVED AE	DRAWING NO. D2056
DATE 92:03:13	DATE 95:11:02	REV. B SHEET 1 OF 1
		SCALE 1:1
		TITLE BELL CRANK
		RE-DESIGN
		MODIFY HOLE SIZE, ADD P/LC OF 7u
		ADD NOTE ON TOLERANCES



B1 ACID ETCH + ALUMINE PER  
DART QSE COS 4.1  
POWDER COAT BLACK STAINLESS  
(4.3.5.7) PER DART  
QSE COS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)  
FINISH: ANODIZE (BLACK) OR  
TOLERANCES ARE PER DART QSE 01B UNLESS OTHERWISE NOTED.

B2

W/O:		WORK ORDER CHANGES					
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 66183
<b>Description: Bell Crank</b>		<b>Part Number: D2056</b>
<b>Inspection Dwg: D2056</b>	<b>Rev: B2</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.751	✓		RQ. 02	
0.900	+/-0.010	.900	✓			
1.000	+/-0.010	1.005	✓			
0.125	+/-0.010	.126	✓			
0.060	+/-0.010	.061	✓			
Ø0.191	+0.005/-0.001	.190	✓			
0.362	+/-0.010	.360	✓			
0.750	+/-0.010	.752	✓			
0.385	+/-0.010	.385	✓			
Ø0.257	+0.006/-0.001	.257	✓			
0.100	+/-0.010	.100	✓			
0.300	+/-0.010	.300	✓			
0.946	+/-0.010	.946	✓			
0.075	+/-0.010	.075	✓			
2.637	+/-0.010	2.635	✓			
0.375	+/-0.010	.375	✓			
Ø0.513-0.518	0.513 - 0.518	.515	✓			
R0.450	+/-0.010	R.450	✓			
R0.125	+/-0.010	R.125	✓			
R0.200	+/-0.010	R.200	✓			
R0.550	+/-0.010	R.550	✓			
R0.263	+/-0.010	R.263	✓			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> A.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11.3.22	<b>Date:</b> 11/03/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	[Signature]

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